

5/28

DART AEROSPACE LTD.	Work Order:	23784
Description: 206/OH-58 Saddle, inboard, Right Side	Part Number:	D2939-2
Drawing: D2939 Rev B	Qty:	6

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Issue Work Order <i>Dwg. not required RF 02/09/16</i>	<i>HA</i>	05.07.08	6
2	STORES	Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length (D6101-001) RF 02/09/16 Batch No: B20570	J.L	05.07.17	6
3	HAAS	Program batch number.	J.L	05.07.17	6
4	QC	Inspect part number and batch number are programmed correctly.	<i>EC</i>	05.07.17	6
5	HAAS	Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet	J.L	05.07.18	6
6	HAAS	Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet	J.L	05.07.18	6
7	HAAS	Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet	J.L	05.07.18	6
8	LAGUN	Machine Keyway and inspect per dwg D2939 & attached dimension sheet	J.L	05.07.18	6
9	METAL	Deburr	J.L	05.07.18	6
10	HAAS	Inspect Level 1	J.L	05.07.18	6
11	QC	Inspect Level 8	<i>EC</i>	05.07.18	6
12	METAL	Acid etch and Alodine as per QSI 005 4.1	<i>IMC</i>	05-7-21	6
13	FINISHING	Powder Coat Gloss White (4.3.5.1) per Dart QSI 005 4.3	<i>IMC</i>	05 07 22	6
14	QC	Inspect Level 3	<i>DL</i>	05/08/08	6
15	STORES	Pack in foam, identify and stock.	<i>DL</i>	05/08/08	6
16	EXPEDITING	Close Work Order Job Cost / Part <i>83.81</i> <i>54C 05/08/09</i> (6) <i>72.61</i>	<i>DL</i>	05/08/09	6

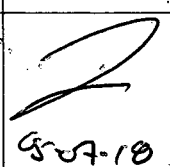
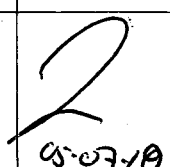
PTO

Rev	Date	Change	Revised By	Approved
A	00.05.29	New Issue	EC	
B	00.06.26	New DWG rev (mpp 2069)	EC	

RELEASED

EC 00.06.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.07.17	7	1 piece is too thin - setup problems		- problem solved - scrap + replace	J.L 05.07.18	 05.07.18		 05.07.18

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05/08/09

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order: 23784
Description: 206 Saddle, Inboard, Right side	Part Number: D2939-2
Inspection Dwg: D2939 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	.127	.125	.122		
B	0.100	0.140		.121	.126	.123	.122		
C	0.100	0.140		.122	.124	.121	.124		
D	0.210	0.230		.217	.217	.217	.215		
E	1.245	1.255		1.249	1.250	1.250	1.249		
F	1.245	1.255		1.249	1.249	1.249	1.249		
G	2.495	2.505		2.498	2.500	2.500	2.500		
H	0.510	0.515		.512	.512	.512	.512		
I	1.572	1.582		1.577	1.577	1.578	1.578		
J	2.495	2.505		2.498	2.499	2.499	2.499		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		.237	.238	.238	.238		
N	0.100	0.140		.115	.116	.120	.118		
O	0.540	0.560		.547	.545	.550	.549		
P	0.490	0.510		.500	.501	.500	.501		
Q	3.715	3.725		3.718	3.720	3.720	3.720		
R	2.720	2.760		2.746	2.744	2.745	2.746		
S	0.240	0.270		.247	.250	.248	.245		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.629	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690						
X	1.250	1.270		1.253	1.252	1.253	1.254		
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	05.07.17

Audited by:	RE
Date:	05.07.17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	

RELEASED
03.06.18

DART AEROSPACE LTD	Work Order:	23784
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.126	.127				
B	0.100	0.140		.125	.126				
C	0.100	0.140		.117	.121				
D	0.210	0.230		.218	.217				
E	1.245	1.255		1.249	1.250				
F	1.245	1.255		1.250	1.249				
G	2.495	2.505		2.500	2.499				
H	0.510	0.515		.512	.512				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.498	2.500				
K	0.257	0.262	DT8683	/	/				
L	0.312	0.317	DT8686	/	/				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.119	.118				
O	0.540	0.560		.548	.550				
P	0.490	0.510		.501	.500				
Q	3.715	3.725		3.719	3.718				
R	2.720	2.760		2.744	2.744				
S	0.240	0.270		.250	.251				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.629				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321	DT8690	/	/				
X	1.250	1.270		1.254	1.253				
Y	1.565	1.585	DT8695 A/B	/	/				
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L
Date:	05-07-18

Audited by:	RF
Date:	05.07.18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF RF	RF

RELEASED
03.06.18 RF

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jul 08, 2005
01:32 pm

Work Order No : 0023784
Project Name : D2939-2
Project For : WK528
Work Order Type : Main
Main WO Number :
House Part Number : D2939-2
Description : 206 Saddle Right Side
Manufactured : Yes
Amount Req'd : 6
Amount Done : 0
Start Date : 07-08-05
Est Finish Date : 07-23-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00